

Work Order ID 111186

January-09-14 12:39:44 PM

Page 1

Item ID: D4635-044

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Aft Ceiling Panel Assembly, RH

Start Date: 09/01/2014 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 24/01/2014 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan: *MP*

Date: *14-01-09*

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	DAS	per ECN
D4635	<i>PD2 DEL DH</i>	27	<i>14509</i>
100		9-89	0.00

\*100\*

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

*x1* *17/01/22*

110

0.00

\*110\*

Small Fab

Memo

0.00

Small Fab

1- Assemble as per Dwg D4635-044

2-Install speaker

3- Install Air valve

4-Install Wiring Harness

5-Install wiring harness

*xc* *17/01/22*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 111186

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Page 2

Item ID: D4635-044 Accept \*N900040100\* Setup Start \*NS1\*

Revision ID: Stop \*NS2\*

Item Name: Aft Ceiling Panel Assembly, RH

Start Date: 09/01/2014 Start Qty: 1.00 \*1\*

Required Date: 24/01/2014 Req'd Qty: 1.00 \*1\*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00 27 9:39 0.00 14/1/23				1			Inspect as per Rwg PE
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00 0.00							thermoforming MLS
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							MLS 14-01-23 Release Rwg as per Res E MF H-1-23

COGNITIVE RECALL  
EFFECTIVE 14/1/23 AUTH 14/1/23  
RELEASED 5 DATE 14/01/24

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Transport									
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# Picklist Print

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Page 1

Work Order ID: 111186

Parent Item: D4635-044

Parent Item Name: Aft Ceiling Panel Assembly, RH

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL  
DL IPP Rev B 12/11/08 Doc Release  
IPP Rev C Dwg. Update 13/07/09 DL verf:DD  
Rev D Dwg Update 14/01/20 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4635-144 Aft Ceiling Replacement Panel Assembly, RH		Manufactured	No			100	Each	1.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				prelim		1							
				111219		1							
D4646-1 Plenum Cap Assembly		Manufactured	No			100	Each	84.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST116		84							
				103832		66							
				92968		6							
				95779		12							
D4652-1 Air Valve, 1.16 Id Disk Type		Manufactured	No			100	Each	203.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				prelim		12							
				111316		12							
				ST099		191							
				111311		191							
D4655-1 Speaker		Manufactured	No			100	Each	90.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST478		48							
				103939		48							
				ST483		42							
				93061		42							



# Picklist Print

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Page 2

Work Order ID: 111186

Parent Item: D4635-044

Parent Item Name: Aft Ceiling Panel Assembly, RH

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

D4708-9  
Lanyard

Manufactured No

100 Each 55.0000

1 1

Location

Loc Qty

Loc Code

ST119

55

111242

49

93919

6

1

14/01/22

D4728-046  
RH Cabin Speaker #3

Manufactured No

100 Each 1.0000

1 1

Location

Loc Qty

Loc Code

ST121

1

93453

1

1

14/01/22

D4743-1  
Speaker Grill

Manufactured No

100 Each 30.0000

1 1

Location

Loc Qty

Loc Code

ST122

30

111220

30

1

14/01/22

MS21044-N08  
Nut

Purchased No

100 Each 265.0000

4 4

Location

Loc Qty

Loc Code

ST315

265

123741

115

m127813

150

4

14/01/22

MS21919-WDG8  
Clamp

Purchased No

100 Each 82.0000

3 3

Location

Loc Qty

Loc Code

ST322

82

m127305

12

m127831

40

m127916

30

3

14/01/22

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Shop Packet Print

Page 2





# Picklist Print

Tuesday, January 21, 2014 1:53:19 PM

Page 3

Work Order ID: 111186

Parent Item: D4635-044

Parent Item Name: Aft Ceiling Panel Assembly, RH

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

MS24693-BB50

SCREW

Purchased

No

Each

100.0000

4

Location

Loc Qty

Loc Code

ST300

100

100

ST293

1000

M127813

1000

st510

376

ST510a

1972

M126319

972

M127255

1000

NAS1149DN832J

Washer

Purchased

No

Each

3,348.0000

4

Location

Loc Qty

Loc Code

ST293

1000

M127813

1000

st510

376

ST510a

1972

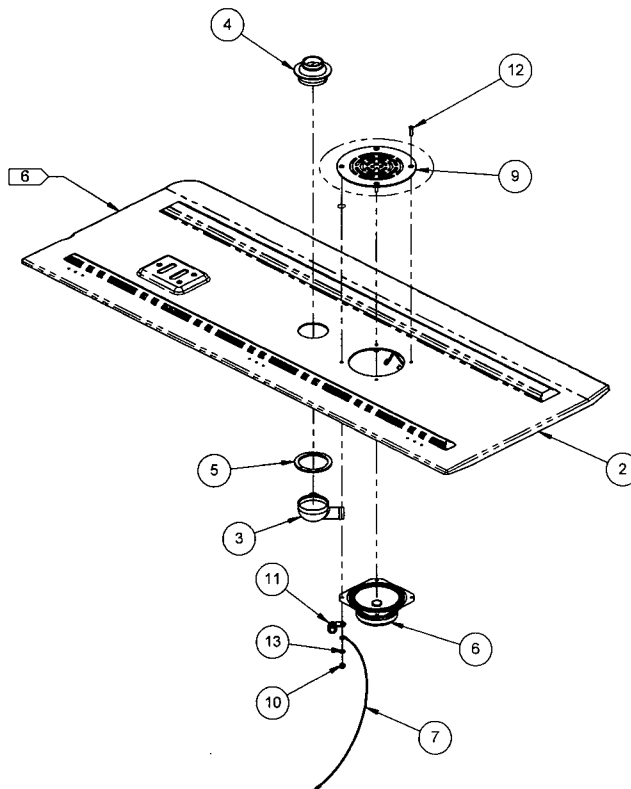
M126319

972

M127255

1000





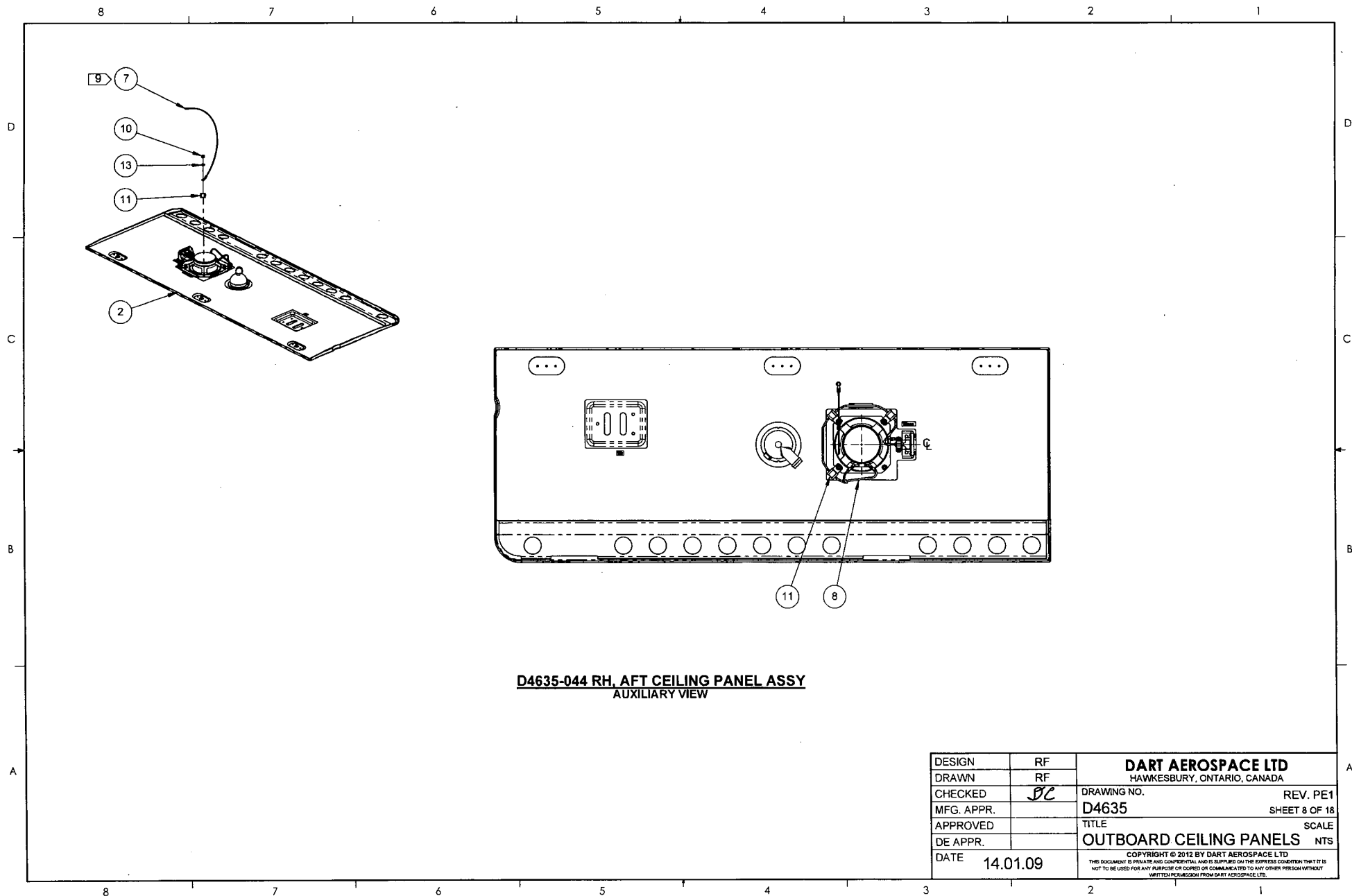
**D4635-044 RH, AFT CEILING PANEL ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 4.40 lbs
- 8) INSTALL D4728-046 WIRE HARNESS PER QSI 048
- 9) ON D4708-9 LANYARD OPEN TO  $\varnothing 0.196$  BOTH ENDS

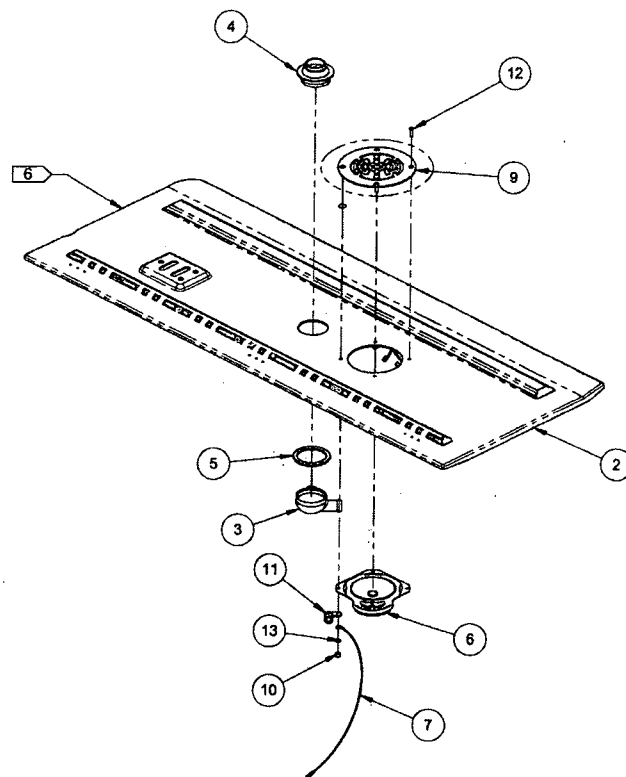
ITEM NO.	QTY. -044	PART NUMBER	DESCRIPTION
1	X	D4635-044	RH, AFT CEILING PANEL ASSY
2	1	D4635-144	RH, AFT CEILING REPLACEMENT PANEL ASSY
3	1	D4646-1	PLENUM CAP ASSEMBLY
4	1	D4652-1	AIR VALVE
5	1	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
6	1	D4655-1	SPEAKER
7	1	D4708-9	LANYARD
8	1	D4728-046	RH SPEAKER #3 HARNESS ASSEMBLY
9	1	D4743-1	SPEAKER GRILL
10	4	MS21044-N08	NUT
11	3	MS21919WDG8	CLAMP
12	4	MS24693-BB50	SCREW
13	4	NAS1149DN832J	WASHER

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	<i>SC</i>	DRAWING NO. REV. PE1
MFG. APPR.		D4635 SHEET 7 OF 18
APPROVED		TITLE SCALE
DE APPR.		<b>OUTBOARD CEILING PANELS</b> NTS
DATE	14.01.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



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**D4635-044 RH, AFT CEILING PANEL ASSY**

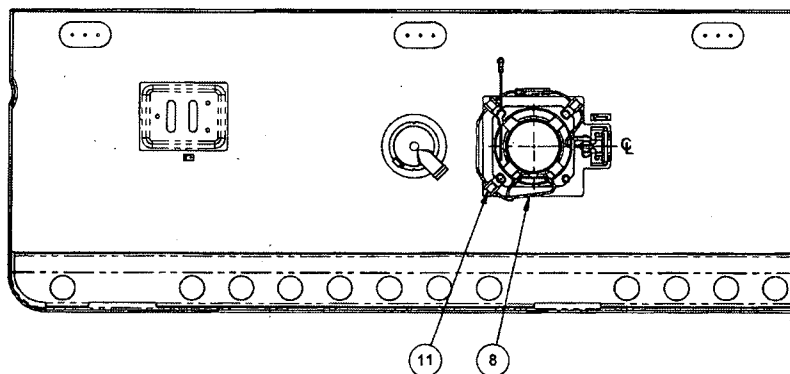
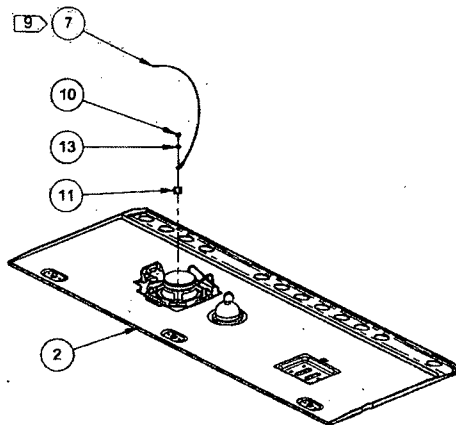
**NOTES:**

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- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 5.0 lbs
- 8) INSTALL D4728-046 WIRE HARNESS PER QSI 048
- 9) ON D4708-9 LANYARD OPEN TO Ø0.196 BOTH ENDS

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DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. E
DRAWN	RF		
CHECKED	DC	DRAWING NO. <b>D4635</b>	SHEET 7 OF 18
MFG. APPR.	DC	TITLE	SCALE
APPROVED	DC	<b>OUTBOARD CEILING PANELS</b>	NTS
DE APPR.	HT	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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**D4635-044 RH, AFT CEILING PANEL ASSY**  
AUXILIARY VIEW

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. E
MFG. APPR.	DC	<b>D4635</b>	SHEET 8 OF 18
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	<b>OUTBOARD CEILING PANELS</b>	NTS
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